

Process Sheet

Split 07/10/11

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT ASSEMBLY	
Job Number	: 30150		Part Number	: D3278041	
Estimate Number	: 10464		Drawing Number	: D3278 REV. B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/8/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/20/2007	
Previous Run	: 29647		Qty:	50	
Written By	: <u>ml</u> 07.01.08		Um:	Each	
Checked & Approved By	: <u>ml</u>				
Comment	: Est:A 04.04.19 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	30150A	SUPPORT	
		Comment: Sub-Component SUPPORT 1 X D3278-1 B <u>29647A</u> (x20)	
2.0	30150B	SUPPORT	
		Comment: Sub-Component SUPPORT 1 X D3278-2 B <u>29647B</u> (x20)	
3.0	D32783	Spacer	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s) Spacer	
		Pick: Qty Part Number Description Batch 1 D3278-3 Spacer <u>29652</u> (x15) / <u>29652</u> (x20)	
4.0	MS20426AD37	RIVET	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 200.0000 Each(s) RIVET	
		Pick: Qty Part Number Description Batch 4 MS20426AD3-7 Rivet <u>M 16199</u> (x19) / <u>M 16199</u> (x80)	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/11	5	000 2 pieces 1x D3278-1 support 1x D3278-3 spacer 2x rivets MS20426AD-3-6 not in val		Be more carefull when removing rivet. Scrap 1x D3278-1 support 1x D3278-3 spacer 2x MS20426AD-3-6	SB 07/01/11	AA 07/01/11	J 07/01/12	AA 07/01/11
		When drilling out the scrap rivet. The drill went went side ways and drill in support and oversize the hole in spacer.						

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30150

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/01/11 19

7.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Mounting Lug

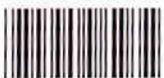
Pick: Packing Kit

Qty	Part Number	Description	Batch
2	D2230-1	Mounting Lug	<i>B29377 (X100)</i>

x40

ml

8.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	<i>M103154 (X20) / M102630 (X52)</i>

*M101938 (X20)
M101938 (X28)*

ml

9.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	AN960JD416	Washer	<i>M101938 (X200)</i>

x80

ml

10.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	MS21042L4	Nut	<i>M19185 (X100)</i>

x40

ml

11.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

ml 07/01/11 X19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:50:28 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 30150

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/01/11 (19)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST105

107/01/11 (19)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

107/01/11

Job Completion



107/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

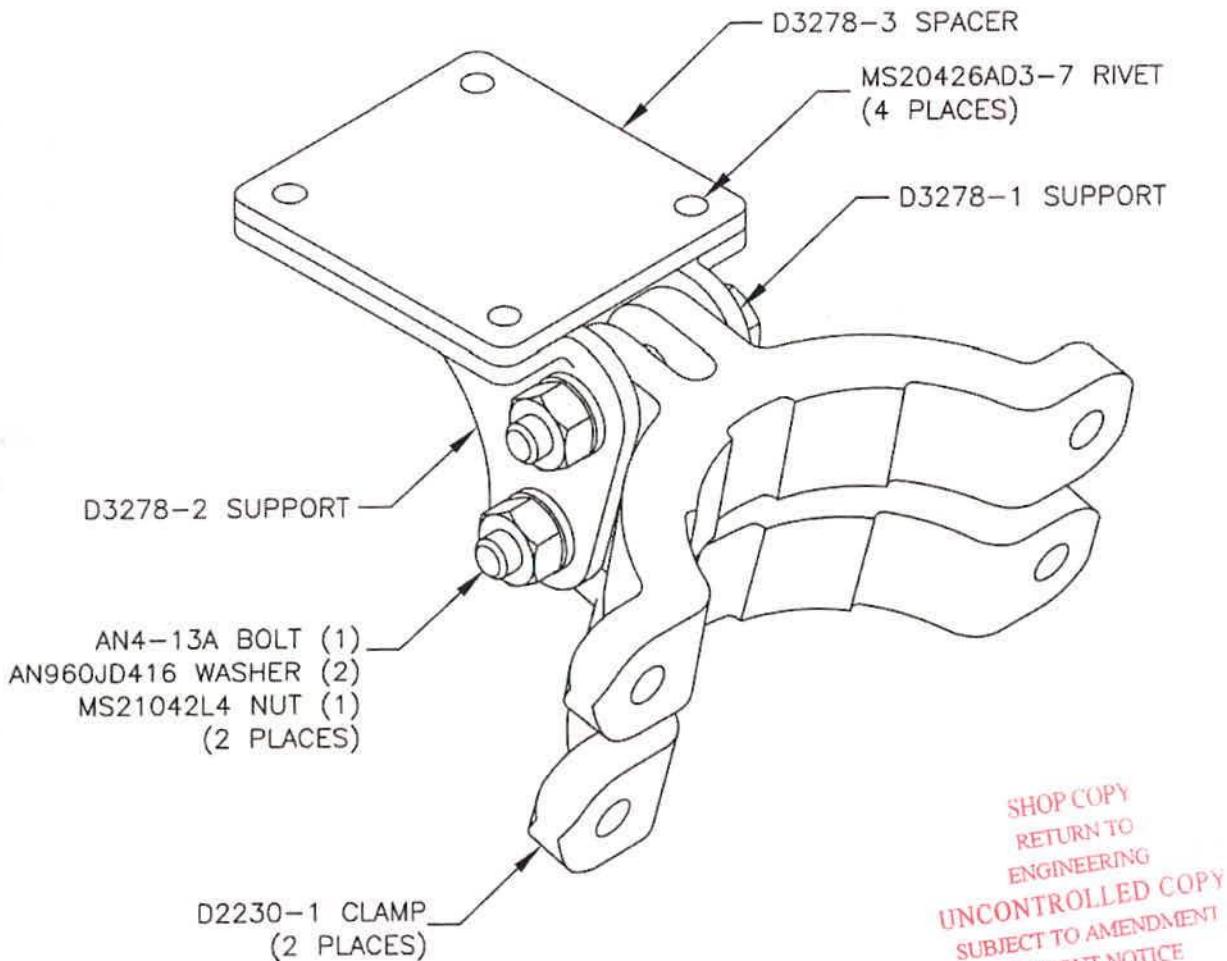
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D3278	REV. B SHEET 1 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	

RELEASED
*05.04.04 - CH*D3278-041 SUPPORT ASSEMBLY

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30150

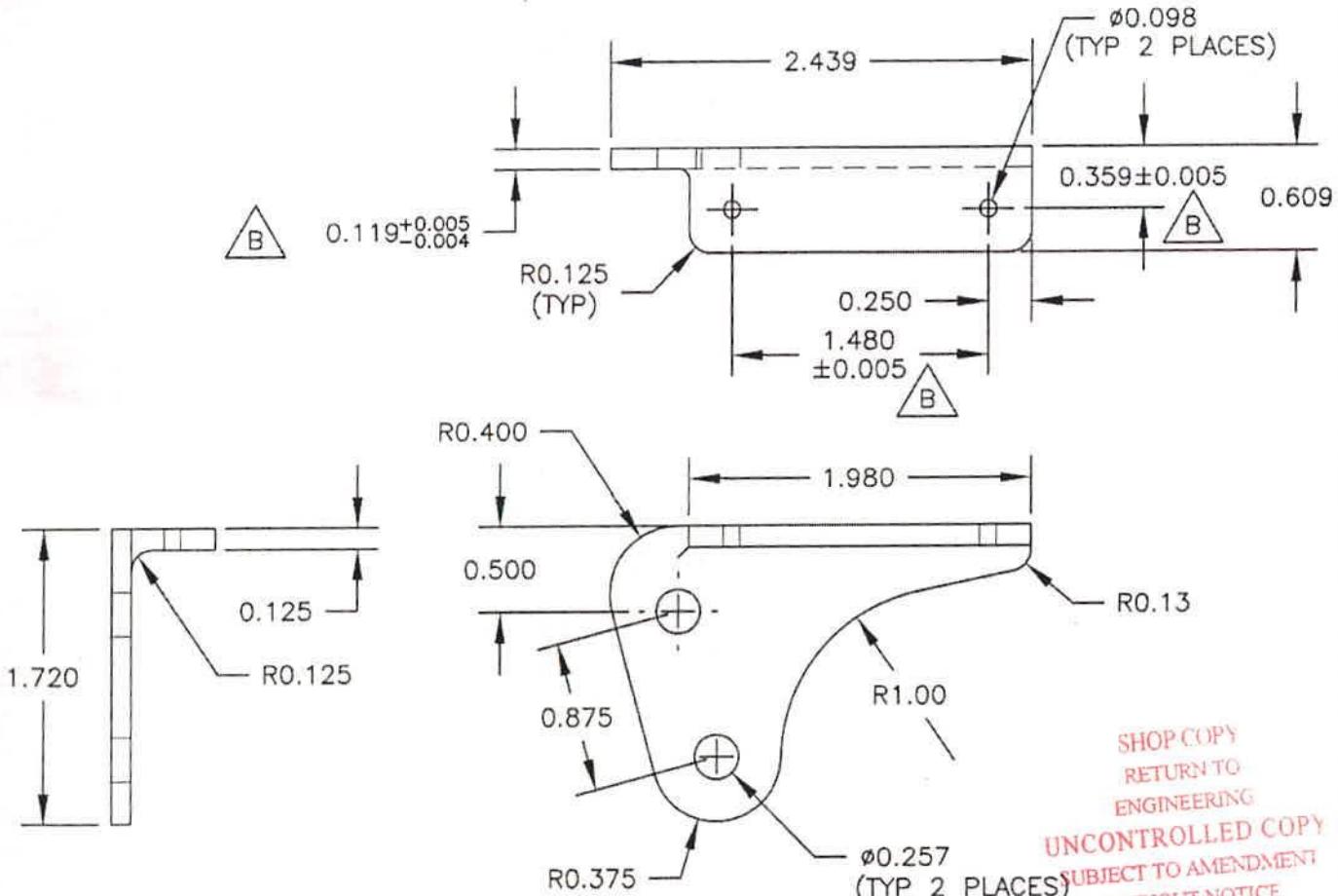
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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3278
DATE 05.03.31		REV. B SHEET 2 OF 3 TITLE SCALE 1:1 SUPPORT ASSEMBLY

RELEASED

05-04-04 *[initials]*D3278-1 SUPPORT (SHOWN)D3278-2 SUPPORT (OPPOSITE)

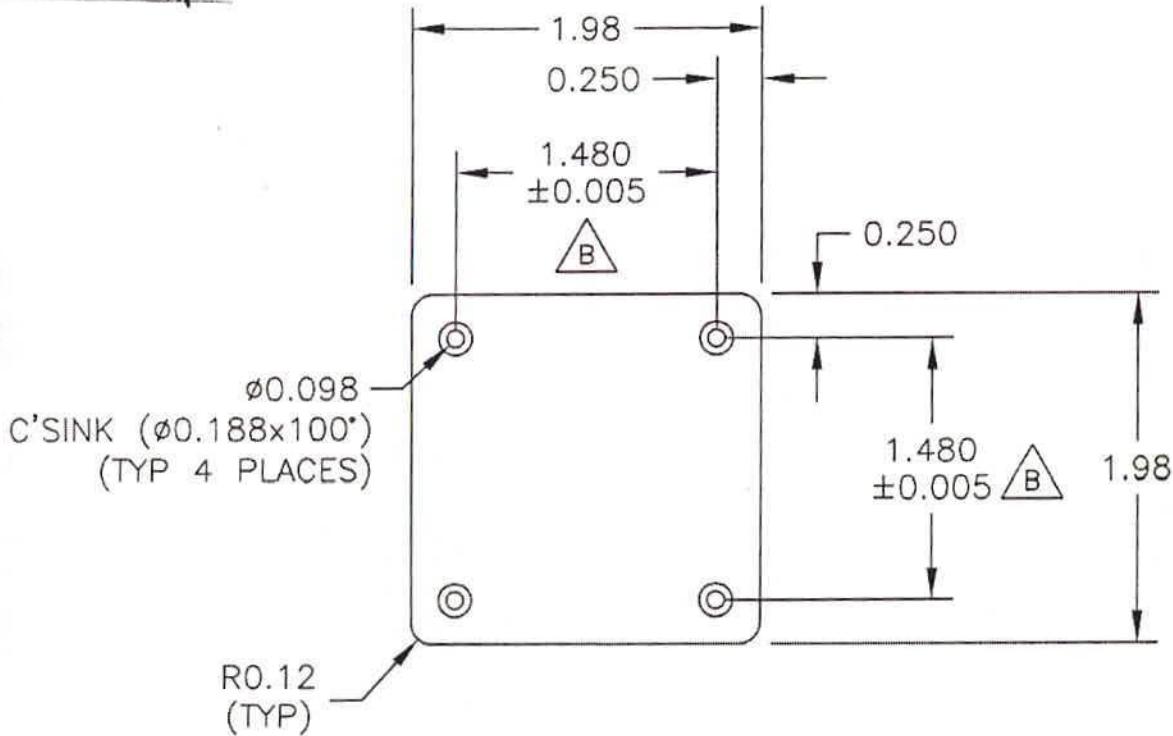
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *MM*

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D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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